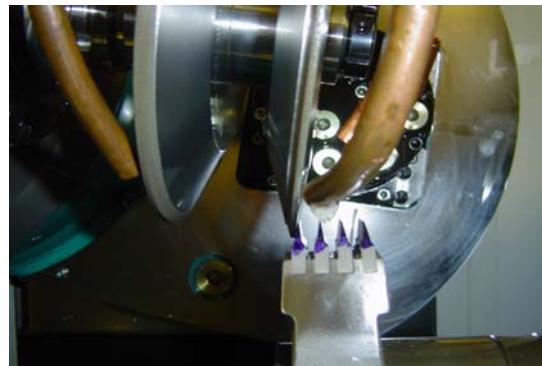
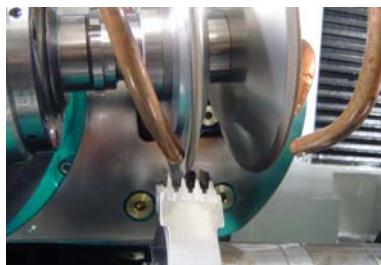


Finger Joint Cutter

A16-280

To achieve a good surface finish on the sides, cupwheels are used for the finishing operation, as shown in the picture besides. In addition, the proposed grinding principle generates perfectly straight clearances.

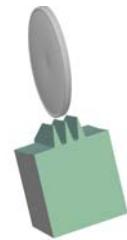


1. Cycletime for Production

Roughing with 14A1

Tool specifications	
$\varnothing 160$ mm, Z 4, Length 32 mm	
Material HSS	
Operations	 Probe  Flute 1  O.D.1  Plung. Rough  Pregrinding  fin. left  fin. Right
Feed [mm/Min]	2000 80 120 40 80 100 100
Power [kW]	3 3 4 3 2 2
Cutting feed [m/s]	32 32 32 32 32 32 32
Used wheels	 15  11  31  31  30  32
Grinding time [s]	21 338 291 571 366 325 325
Total cycle time	37 Min 17

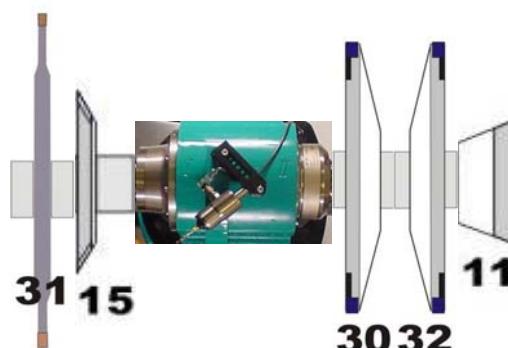
Finishing with 12C9



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

15 Ø125 1V1 B126
11 Ø100 11V9 B126
31 Ø250 14A1 B126
30 Ø250 12C9 B126
32 Ø250 14A1 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP, 20.11.07

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TECHNOLOGY
FOR TOOLING